

Date: Tuesday, 7/17/2007 2:00:13 PM
 User: Kim Johnston

Process Sheet

(2)

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 33587
 Estimate Number : 11736
 P.O. Number : N/A
 This Issue : 7/17/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : N/A
 Written By : 7/17/07.14
 Checked & Approved By : 7/17/07.14
 Comment : Est: B 04.05.14 Reformat, Added Step 5KJ/JLM

Drawing Name : ARM
 Part Number : D27951
 Drawing Number : D2795 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 8/3/2007 Qty: 21 Um: Each

Additional Product:

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6B0500X06000 6061-T6 Bar .50" x 6.0"



Comment: Qty.: 1.3913 f(s)/Unit Total: 29.2163 f(s)
 6061-T6 Bar .50" x 6.0"
 Material: 6061-T6 (QQ-A-200/8) 0.500" thick
 (M6061T6B0.500x06.000)
 Identify for D2795-1
 Batch: 105445

B6 07-08-05 21

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: 6.000" x 0.05" x 15.800" long Bar

B6 07-08-05 21

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA106 and Dwg D2795
 Identify as D2795-1
 C'sink Ø0.375" x 100° as per Dwg D2795
 Deburr and Tumble

B6 07-08-05 19

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B6 07-08-05 19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/08/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/04	3	1 piece. the wall ^{is} too small. .223" supposed to be .250" R.C.: Box 18 + orig. in.	<i>[Signature]</i> QSI0412	1 scrap - No replace. destroy	<i>[Signature]</i> 07/08/08	<i>[Signature]</i> 07-08-08	<i>[Signature]</i> QSI0412	<i>[Signature]</i> 0708-08
07.08/06	3	1 part. 6.049 dim. is 6.033 All other dim. are good R.C.: part shifted during machining	<i>[Signature]</i> QSI0412	1 Scrap - No replace destroy	<i>[Signature]</i> 07/08/08	<i>[Signature]</i> 0708-08	<i>[Signature]</i> QSI0412	<i>[Signature]</i> 0708-08

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 2:00:13 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 33587

Part Number: D27951

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07/08/07 19

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57240

07/18/08 (19)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/18/08 (19)

Job Completion



CL 07/08/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	33587
Description: Arm		Part Number:	D2795-1
Inspection Dwg: D2795 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.000	✓			
6.049	+/-0.010	6.045	✓			
R0.030	+/-0.010	.030	✓			
Ø0.191	+0.005/-0.000	.191	✓			
2.311	+/-0.010	2.310	✓			
0.250	+/-0.010	.250	✓			
9.358	+/-0.005	9.361	✓			
Ø0.507	+0.000/-0.001	.5065	✓			
2.033	+/-0.005	2.033	✓			
1.000	+/-0.010	1.000	✓			
2.500	+/-0.010	2.500	✓			
1.347	+/-0.010	1.347	✓			
0.250	+/-0.010	.250	✓			
R0.125	+/-0.010	.125	✓			
Ø0.375 x 100°	+0.005/-0.000	.376	✓			
0.500	+/-0.010	.500	✓			

Measured by:	RL
Date:	07-05-05

Audited by:	me
Date:	07/08/06

Prototype Approval:	N/A
Date:	N/A

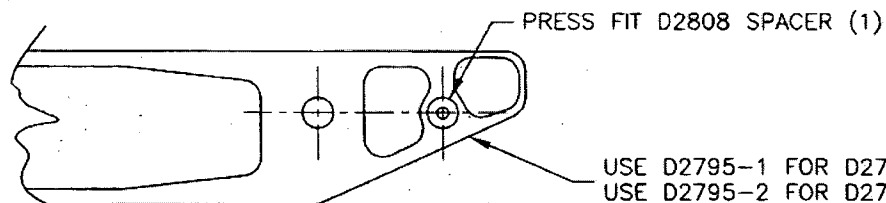
Rev	Date	Change	Revised by	Approved
A	04.02.10	New Issue	KJ/RF	RF

DART

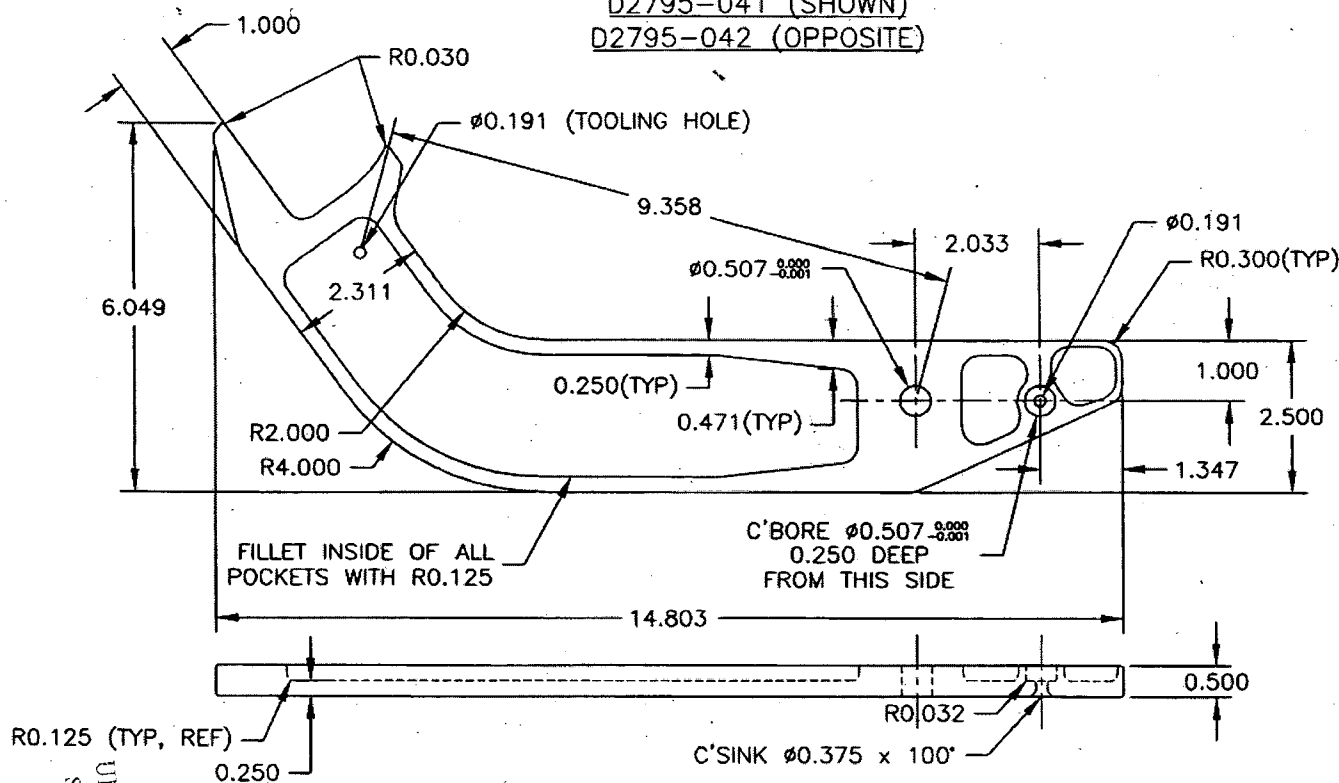


DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 00.11.03	TITLE ARM	REV. A
A	00.11.03	NEW ISSUE
		SHEET 1 OF 1
		SCALE 1:3

RELEASED
00.11.13



D2795-041 (SHOWN)
D2795-042 (OPPOSITE)



D2795-1 (SHOWN)
D2795-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2795-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP CODE
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
35587